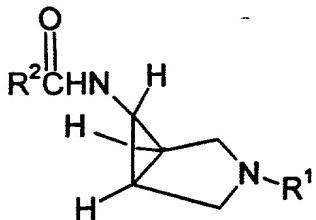


5

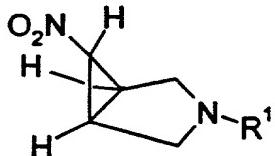
Claims

1. A process for preparing a compound of the formula



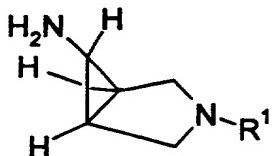
wherein

- R¹ is benzyl, wherein the phenyl of the benzyl may be substituted by one or more of
10 C₁-C₆ alkyl, C₁-C₆ alkoxy, halo, nitro, amino or trifluoromethyl, and
R² is C₁-C₆ alkyl, trifluoromethyl, or phenyl which may be substituted by one or more
of C₁-C₆ alkyl, C₁-C₆ alkoxy, halo, nitro, amino or trifluoromethyl, which comprises
(a) reducing a compound of the formula



II

- 15 wherein R¹ is as defined above, in the presence of iron and a organic solvent under acidic conditions, and
(b) acylating the compound of formula III formed:



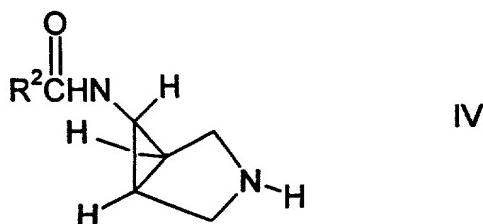
III

- 20 with an acylating agent of the formula R²C(O)X wherein R² is as defined above, and X is a leaving group.

2. A process according to claim 1 wherein the compound of the formula III formed in step (a) is not isolated before acylation step (b).

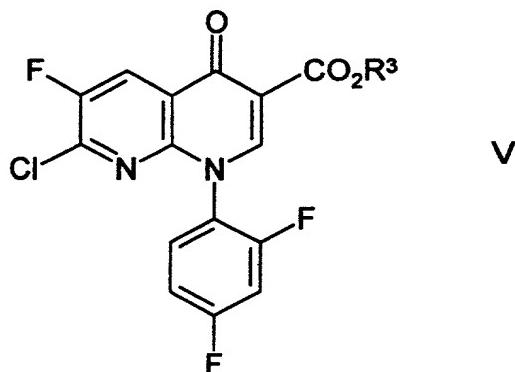
3. A process according to claim 1 or 2 wherein the compound of formula I wherein R¹ is as defined in claim 1, is subjected to debenzylation to form the compound of the
25 formula

EXPRESS MAIL NO. EL374868170US

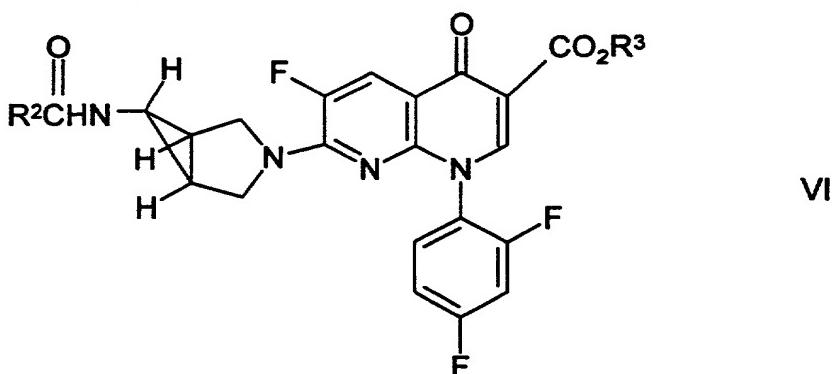


4. A process according to claim 3 wherein the debenzylation is by reaction with hydrogen and palladium catalyst in acetic acid and an organic solvent.

5. A process according to claim 3 or 4 further comprising reacting the compound of formula IV with a compound of the formula

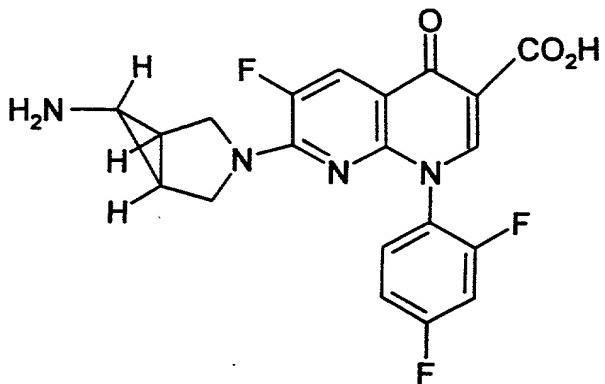


10 wherein R³ is C₁-C₆ alkyl, to form a compound of the formula



wherein R² is as defined in claim 1

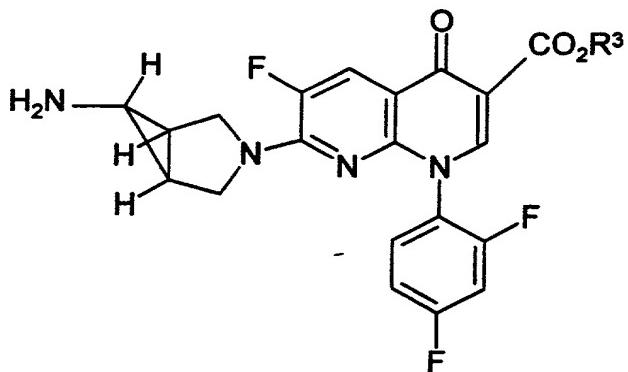
15 6. A process according to claim 5 further comprising hydrolysis of the compound of formula VI with methanesulfonic acid, water and an organic solvent to form the monomethanesulfonic acid salt of the compound of the formula



VII

5

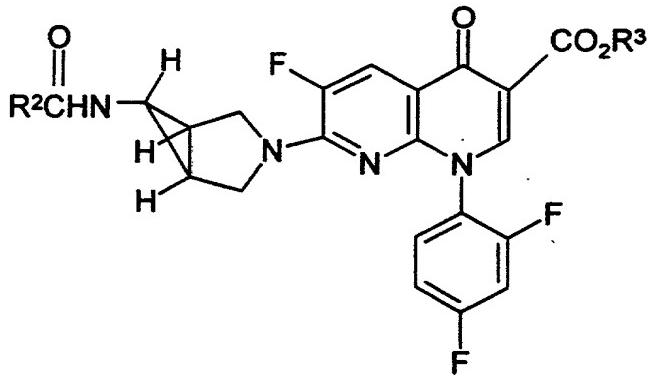
7. A process according to claim 5 or 6 further comprising hydrolysis of the compound of formula VI with methanesulfonic acid and R³OH wherein R³ is as defined in claim 5 to form the monomethanesulfonic acid salt of the compound of the formula



VIII

10

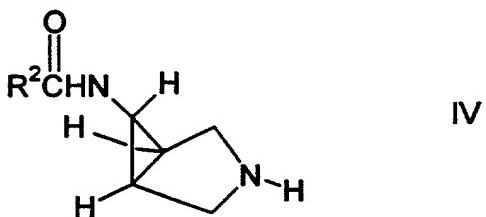
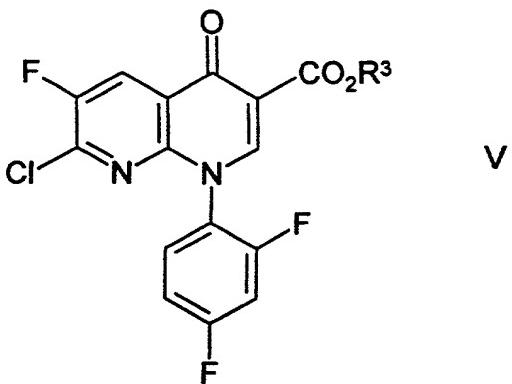
8. A process for the preparation of a compound of the formula



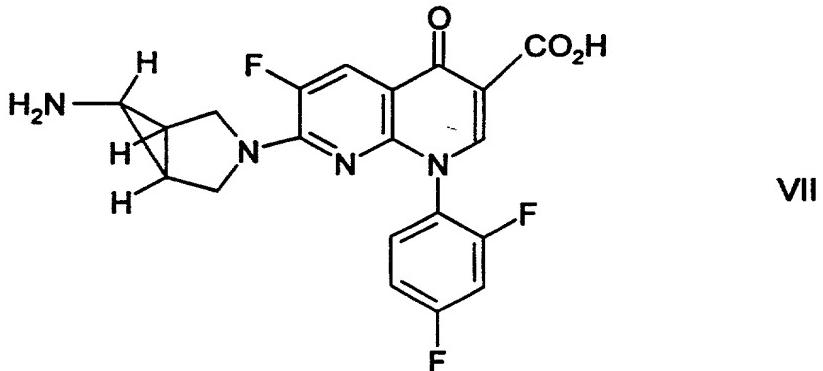
VI

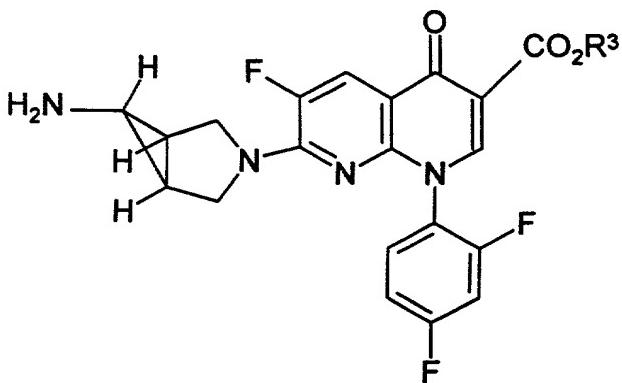
wherein R² is R² is C₁-C₆ alkyl, trifluoromethyl, or phenyl which may be substituted by one or more of C₁-C₆ alkyl, C₁-C₆ alkoxy, halo, nitro, amino or trifluoromethyl, and

R³ is C₁-C₆ alkyl, which comprises reacting a compound of the formula



9. A process according to claim 8, further comprising hydrolysis of the compound of formula VI with methanesulfonic acid, water and an organic solvent to form the monomethanesulfonic acid salt of the compound of the formula
10. A process according to claim 8, further comprising hydrolysis of the compound of formula VI with methanesulfonic acid and R³OH wherein R³ is as defined in claim 5 to form the monomethanesulfonic acid salt of the compound of the formula

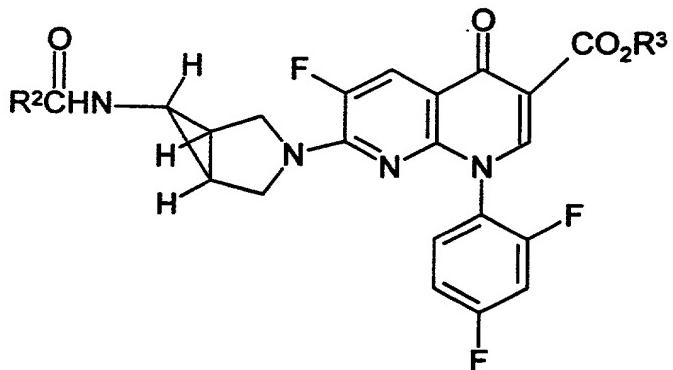




VIII

5

- ### 11. A compound of the formula

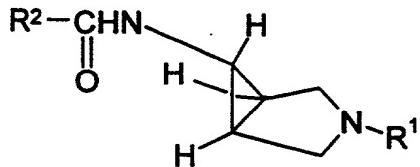


VI

wherein

- R²** is C₁-C₆ alkyl, trifluoromethyl, or phenyl which may be substituted by one or more
10 of C₁-C₆ alkyl, C₁-C₆ alkoxy, halo, nitro, amino or trifluoromethyl, and
R³ is C₁-C₆ alkyl.

- ### 12. A compound of the formula



1

wherein

- 15 R¹ is hydrogen or benzyl, wherein the phenyl of the benzyl may be substituted by one or more of C₁-C₆ alkyl, C₁-C₆ alkoxy, halo, nitro, amino or trifluoromethyl, and

- R^2 is C₁-C₆ alkyl, trifluoromethyl, or phenyl which may be substituted by one or more of C₁-C₆ alkyl, C₁-C₆ alkoxy, halo, nitro, amino or trifluoromethyl.